

Date: Monday, 3/19/2007 4:26:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OH-58 SKIDTUBE
Job Number : 31286	
Estimate Number : 10465	
P.O. Number : <i>N/A</i>	Part Number : D058672011
This Issue : 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : <i>N/A</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 31008	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/10/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.03.20	
Comment : Est Rev:F 02.06.24 Re-format; CHG002 (MPP2251); ECN 258 K J Est Rev:G 07-03-08 As per IIN D058-672 Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-011 CHG003

CL *KS 07.03.26* *(1)*

2.0	31286A	OH-58 SKIDTUBE ASSEMBLY
-----	--------	-------------------------



Comment: Sub-Component OH-58 SKIDTUBE ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D058672043	GROUND HANDLING KIT
-----	------------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GROUND HANDLING KIT

Batch: *1531/31*

5.0	D29321	206 Saddle Left side
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
2 D2932-1	Saddle	<i>028937</i>

7/4/30 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: OH-58 SKIDTUBE

Job Number: 31286

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29331

206 Saddle Left



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2933-1

Saddle

1330945

1330945

7.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

1330945

8.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

1330946

9.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

14103395

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

16 D2652

Bushing

1329332

11.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

1100743

7/4/30 SP

W/O:		WORK ORDER CHANGES					
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Drawing Name: OH-58 SKIDTUBE

Job Number: 31286

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L3 Nut (or -3)

M103585 X

13.0

AN510A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt

M102404 X

14.0

AN512A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-12A Bolt

M102659 X

15.0

AN960JD516



Comment: Qty.: 8.00000 Each(s)/Unit Total : 8.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD516 Washer

M103641 X

16.0

AN46A



Comment: Qty.: 12.00000 Each(s)/Unit Total : 12.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-6A Bolt

M102956 M102115 X
10

17.0

AN960JD416



Comment: Qty.: 24.00000 Each(s)/Unit Total : 24.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer

M102929 X 7/4/30 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 SKIDTUBE

Job Number: 31286

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or -4)

1103914

X

19.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 D2712

Set Screw

1326481

X

20.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

1329353

✓

21.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch:

118519

X

22.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN970-4

Washer

1103344

X

23.0

MS210424

USE MS21042L4



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

USE MS21042L4

Batch:

1103914

n/a

7/4/30 SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: OH-58 SKIDTUBE

Job Number: 31286

Part Number: D058672011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 07/05/01 (1) C207105101 (1)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-011

Location:

Rev B *7/5/150*

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 207105102

Job Completion



✓ 07.05.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	672 -011	672 -012	672 -013	672 -014	672 -041	672 -043	Part Number	Description
	X						D058-672-011	SKIDTUBE INSTALLATION, LH
		X					D058-672-012	SKIDTUBE INSTALLATION, RH
			X				D058-672-013	SKIDTUBE INSTALLATION, LH
				X			D058-672-014	SKIDTUBE INSTALLATION, RH
	1	1	1	1	X		D058-672-041	REPLACEMENT SKIDTUBE
	1	1	1	1		X	D058-672-043	GROUND HANDLING KIT
1					1		D2922-041	SKIDTUBE ASSEMBLY
2					20		D2651-1	* PLUG
3					20		D2651-3	* O-RING
4					1		D2646	* AFT CAP
5					2		MS27039-1-08	* SCREW
6					2		AN960JD10L	* WASHER
7					4		D2648-3	* WEARPAD
8					1		D2648-5 (OR D2648-3)	* WEARPAD
9					1		D2656-15	* WEARSHOE
10					1		D2656-21	* WEARSHOE
11					1		D2924	* WEARSHOE
12					50		MS27039-1-08	* SCREW
13					50		AN960JD10L	* WASHER
14					50		AKS7-1032-130	* INSERT
20	1		1				D2932-1	SADDLE OUTSIDE, LH
20		1		1			D2932-2	SADDLE OUTSIDE, RH
21	1		1				D2933-1	SADDLE INSIDE, LH
21		1		1			D2933-2	SADDLE INSIDE, RH
22	1						D2932-1	SADDLE OUTSIDE, LH
22		1					D2932-2	SADDLE OUTSIDE, RH
22			1				D2938-1	SADDLE OUTSIDE, LH
22				1			D2938-2	SADDLE OUTSIDE, RH
23	1						D2933-1	SADDLE INSIDE, LH
23		1					D2933-2	SADDLE INSIDE, RH
23			1				D2939-1	SADDLE INSIDE, LH
23				1			D2939-2	SADDLE INSIDE, RH
24	2	2	2	2			D2934	SADDLE SPACER
25	2	2	2	2			D2935	SADDLE SPACER
26	8	8	8	8			AN3-41A	BOLT
27	16	16	16	16			D2652	BUSHING
28	8	8	8	8			AN960JD10	WASHER
29	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
30	4	4	4	4			AN5-10A	BOLT
31	4	4	4	4			AN5-12A	BOLT
32	8	8	8	8			AN960JD516	WASHER
33	12	12	12	12			AN4-6A	BOLT
34	24	24	24	24			AN960JD416	WASHER
35	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
36	10	10	10	10			D2712	SET SCREW
40	1	1	1	1			D2707-043 (OR D2968-043)	TOW RING
41	1	1	1	1			AN960JD1016	WASHER
42	1	1	1	1			AN970-4	WASHER
43	1	1	1	1			MS21042-4	NUT (OR MS21042L4)
50					2		D3046-041	LUG BRACKET
51					4		AN3-37A	BOLT
52					8		D2652	BUSHING
53					4		AN960DJ10	WASHER
54					4		MS21042-3	NUT (OR MS21042L3)

* DENOTES THAT PART IS INCLUDED WITH D2922-041 ASSEMBLY

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Revision: C

Date: 06.11.14

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 WITHOUT NOTICE
 WORK ORDER
 NO. 3286

Date: Monday, 3/19/2007 4:27:21 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 0H-58 SKIDTUBE ASSEMBLY
Job Number	: 31286A		
Estimate Number	: 10475		
P.O. Number	: <i>N/A</i>	Part Number	: D058672041
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2922 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: A1
Previous Run	: 31008A	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/10/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev:C 02.06.28 Re-format; ECN 258 KJ Est Rev:D 06.02.06 Added Dt8025 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001 *N/A*

2.0	D2620	Bent 206 Skidtube
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD *BE 07-03-22*

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube *BE 07-03-22*2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod. *BE 07-03-22*A/R Aluminum Rod *m103317/m102421*3-Cut aft end of D2620 bent tube as per dwg D2922 *pm 07-03-220*4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia. *pm 07-03-220*5-Drill holes for wearplates using DT 8487 Open to 0.297" dia. *pm 07-03-220*6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit *pm 07-03-220*8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922 *pm 07-03-220*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9-Deburr and Blow out all chips form inside the tube

Pm 07-03-22

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 07-03-22

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2923

Web

B31338

Pm 07-03-27

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

Pm 07-03-27

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

Pm 07-03-27

3-Deburr and Blow out all chips from inside the tube

Pm 07-03-27

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R Sikaflex-291

m103497 / m103561

Sikaflex expire date: *07-10-01*

Pm 07-03-27

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-3-28

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14400

BE 07-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

31112 BE 07-03-28

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M102421 BE 07-03-28

3-Grind welds flush as per Dwg D2922

BE 07-03-28

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

BE 07-03-28

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/28 ①

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/28 ①

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-04-24 ①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/25 ①

15.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

B29177 FL 07/04/25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-15 Wearshoe

Batch

B29335

17.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-21 Wearshoe

Batch

B20917

18.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2924 Wearshoe

Batch

B22595

19.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 MS27039-1-08 Screw

Batch

M102630

20.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 AN960JD10L Washer

Batch

M102832

for 07/04/25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

21.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description

50 ALS4-1032-130 Insert

or (see QSI 017)

Batch

m103495 (x29)

m102475

~~m103618~~ (x21)

22.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description

20 D2651-1 Plugs

Batch

B30943

23.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description

20 D2651-3 O-Rings

Batch

B30815

24.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2646 Aft Cap

Batch

B30119

25.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description

2 MS27039-1-08 Screw

Batch

~~m102630~~ m102630

FL 07/04/25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:27:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #: Machine Or Operation: Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description
2 AN960JD10L Washer

Batch:

M102832

FZ - 07/04/25 (1)

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 07/10 M103561

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 07/10 M103561

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

M103707

FZ 07/04/20

Batch:

(1)

28.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/30

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/30

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

3/286
PPP PO 9/5/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:27:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE ASSEMBLY

Job Number: 31286A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Stop 5/02

Job Completion



u 8/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	<i># CP</i> 01.08.20	<i>φ0.640 WAS φ0.625</i>	

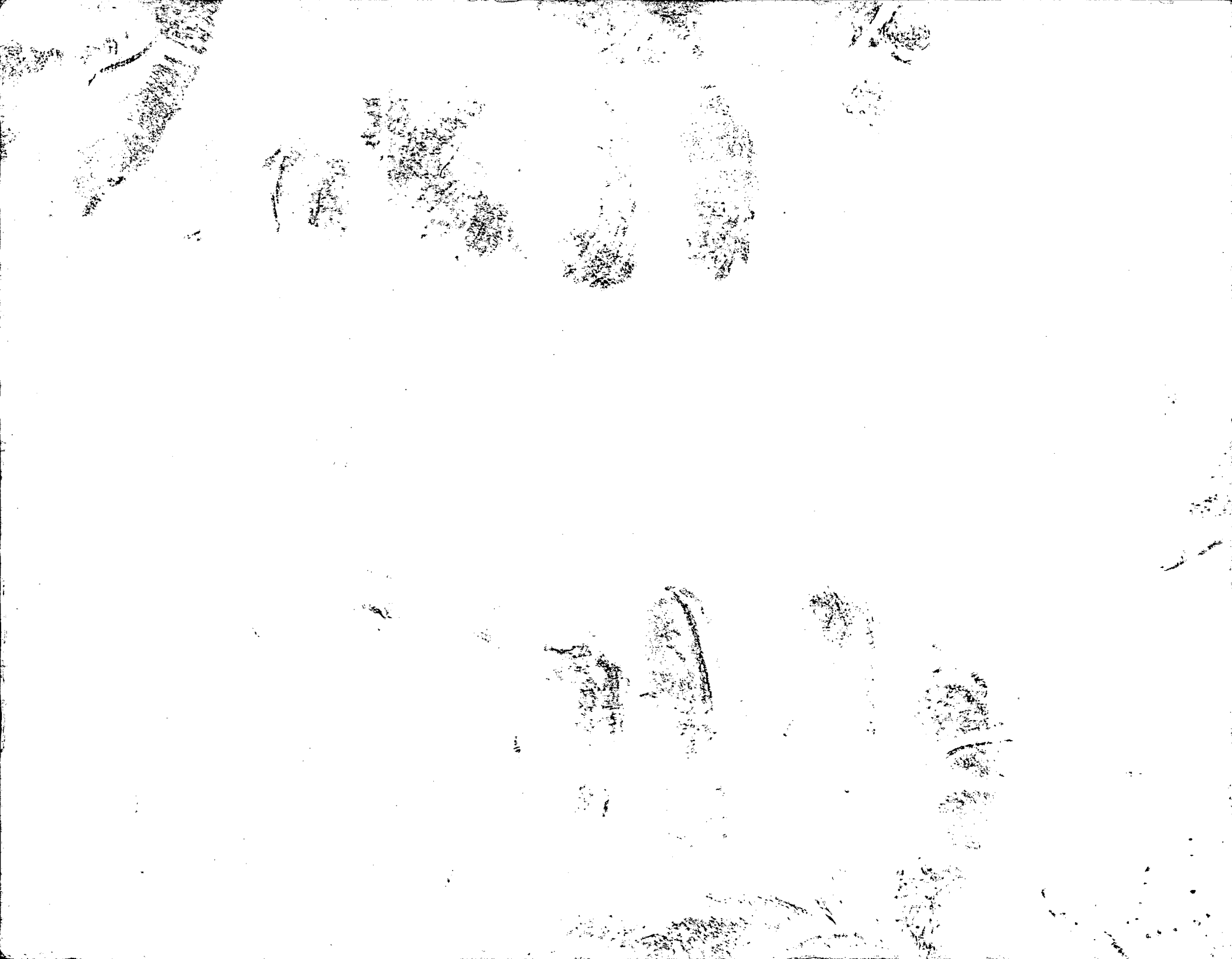
RELEASED
00.05.11 *#*

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

SHOP COPY
RETURN TO
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CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31286A*



NO. 99

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A0586 72041 / B3 1008 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/20 Qualifier David Newel